



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

U/R

**D5735-043**  
**Job Sheet 203330**

Accounting Job RD19-1069-01



Part No: D5735-043

Job Qty: 1 pcs

Part Name: MID Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1206 DWG D5735 Rev.A IPP Rev. A 19.11.08 New issue DP Verify DD

**POSITIVE RECALL**

EFFECTIVE 19/11/19 AUTH *ML*

Ship Via:

RELEASED DATE

### Bill of Materials

### Job Routing

| Op No | Operation                 | Qty   | Start Date | Due Date | Standard Setup Hrs | Run Hrs | Workcenter/Supplier      | Sign-off |
|-------|---------------------------|-------|------------|----------|--------------------|---------|--------------------------|----------|
| 100   | Large Fab - Welded Assy-1 | 1 pcs | 11/29/19   | 11/29/19 | 0.00               | 0.80    | Large Fab - 1            |          |
|       |                           |       |            |          |                    |         | Large Fab - 10           |          |
|       |                           |       |            |          |                    |         | Large Fab - 2            |          |
|       |                           |       |            |          |                    |         | Large Fab - 3            |          |
|       |                           |       |            |          |                    |         | Large Fab - 4            |          |
|       |                           |       |            |          |                    |         | Large Fab - 5            |          |
|       |                           |       |            |          |                    |         | Large Fab - 6            |          |
|       |                           |       |            |          |                    |         | Large Fab - 7            |          |
|       |                           |       |            |          |                    |         | Large Fab - 8            |          |
|       |                           |       |            |          |                    |         | Large Fab - 9            |          |
|       |                           |       |            |          |                    |         | Large Fab - 11 (Various) |          |
|       |                           |       |            |          |                    |         | Large Fab - 12           |          |
| 110   | QC 9                      | 1 pcs | 11/29/19   | 11/29/19 | 0.00               | 0.00    | QC 9 - 10                |          |
|       |                           |       |            |          |                    |         | QC 9 - 18                |          |
|       |                           |       |            |          |                    |         | QC 9 - 24                |          |
|       |                           |       |            |          |                    |         | QC 9 - 43                |          |
|       |                           |       |            |          |                    |         | QC 9 - 50                |          |
|       |                           |       |            |          |                    |         | QC 9 - 9                 |          |
| 120   | QC 5                      | 1 pcs | 11/29/19   | 11/29/19 | 0.00               | 0.00    | QC 5 - 10                |          |
|       |                           |       |            |          |                    |         | QC 5 - 12                |          |
|       |                           |       |            |          |                    |         | QC 5 - 17                |          |
|       |                           |       |            |          |                    |         | QC 5 - 18                |          |
|       |                           |       |            |          |                    |         | QC 5 - 19                |          |
|       |                           |       |            |          |                    |         | QC 5 - 22                |          |
|       |                           |       |            |          |                    |         | QC 5 - 24                |          |
|       |                           |       |            |          |                    |         | QC 5 - 3                 |          |
|       |                           |       |            |          |                    |         | QC 5 - 43                |          |
|       |                           |       |            |          |                    |         | QC 5 - 49                |          |
|       |                           |       |            |          |                    |         | QC 5 - 51                |          |
|       |                           |       |            |          |                    |         | QC 5 - 58                |          |
|       |                           |       |            |          |                    |         | QC 5 - 68                |          |



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Container No: S235625



Part: D5735-043

Job No: 203330

Serial No/Batch: S235625

Revision: U/R A

Inspector:

Exp Date:

Instructions:

Date: 11/28/19

Plex 11/15/19 9:17 AM Dart.lajeunesse.marie

|     |                             |       |          |           |                        |  |
|-----|-----------------------------|-------|----------|-----------|------------------------|--|
|     |                             |       |          |           | QC 5 - 9               |  |
|     |                             |       |          |           | QC 5 - 50              |  |
|     |                             |       |          |           | QC 5 - 30              |  |
|     |                             |       |          |           | QC 5 - 40              |  |
|     |                             |       |          |           | QC 5 - 61              |  |
|     |                             |       |          |           | QC 5 - 81              |  |
|     |                             |       |          |           |                        |  |
| 150 | Spray Paint - 2 - B4B       | 1 pcs | 11/29/19 | 0.00 0.17 | Spray Paint - 1 - B4B  |  |
|     |                             |       |          |           | Spray Paint - 2 - B4B  |  |
|     |                             |       |          |           | Spray Paint - 3 - B4B  |  |
|     |                             |       |          |           | Spray Paint - 4 - B4B  |  |
| 160 | QC 5                        | 1 pcs | 11/29/19 | 0.00 0.00 | QC 5 - 10              |  |
|     |                             |       |          |           | QC 5 - 12              |  |
|     |                             |       |          |           | QC 5 - 17              |  |
|     |                             |       |          |           | QC 5 - 18              |  |
|     |                             |       |          |           | QC 5 - 19              |  |
|     |                             |       |          |           | QC 5 - 22              |  |
|     |                             |       |          |           | QC 5 - 24              |  |
|     |                             |       |          |           | QC 5 - 3               |  |
|     |                             |       |          |           | QC 5 - 43              |  |
|     |                             |       |          |           | QC 5 - 49              |  |
|     |                             |       |          |           | QC 5 - 51              |  |
|     |                             |       |          |           | QC 5 - 58              |  |
|     |                             |       |          |           | QC 5 - 68              |  |
|     |                             |       |          |           | QC 5 - 9               |  |
|     |                             |       |          |           | QC 5 - 50              |  |
|     |                             |       |          |           | QC 5 - 30              |  |
|     |                             |       |          |           | QC 5 - 40              |  |
|     |                             |       |          |           | QC 5 - 61              |  |
|     |                             |       |          |           | QC 5 - 81              |  |
|     |                             |       |          |           |                        |  |
| 170 | Packaging 3-1 - Stock - B4B | 1 pcs | 11/29/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |  |
|     |                             |       |          |           | Packaging 3 - 2 - B4B  |  |
|     |                             |       |          |           | Packaging 3 - 3 - B4B  |  |
|     |                             |       |          |           | Packaging 3 - 4 - B4B  |  |
|     |                             |       |          |           | Packaging 3 - 5 - B4B  |  |
|     |                             |       |          |           | Packaging 3 - 6 - B4B  |  |
|     |                             |       |          |           | Packaging 3 - 7 - B4B  |  |
|     |                             |       |          |           | Packaging 3 - 8 - B4B  |  |
|     |                             |       |          |           | Packaging 3 - 9 - B4B  |  |
|     |                             |       |          |           | Packaging 3 - 10 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 11 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 12 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 13 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 14 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 15 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 16 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 17 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 18 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 19 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 20 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 21 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 22 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 23 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 24 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 25 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 26 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 27 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 28 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 29 - B4B |  |
|     |                             |       |          |           | Packaging 3 - 30 - B4B |  |
|     |                             |       |          |           |                        |  |





|                |       |          |      |      |                        |  |
|----------------|-------|----------|------|------|------------------------|--|
|                |       |          |      |      | Packaging 3 - 31 - B4B |  |
|                |       |          |      |      | Packaging 3 - 32 - B4B |  |
|                |       |          |      |      | Packaging 3 - 33 - B4B |  |
|                |       |          |      |      | Packaging 3 - 34 - B4B |  |
|                |       |          |      |      | Packaging 3 - 35 - B4B |  |
|                |       |          |      |      | Packaging 3 - 36 - B4B |  |
| 180 QC 21 - SA | 1 pcs | 11/29/19 | 0.00 | 0.00 | QC 21 - SA - 21        |  |
|                |       |          |      |      | QC 21 - SA - 70        |  |
|                |       |          |      |      | QC 21 - SA - 53        |  |

Part Op 100 - 1- Weld D5736-043 to wearplate as per dwg D5735 304 S.S. Welding Rod BATCH #: \_\_\_\_\_ 2-  
 Descriptions: Transfer drill holes in bar 3- Use DT \_\_\_\_\_ to check fit after welding 4- ENSURE WELDED CLAMP FITS AROUND A  
 3.62" DIAMETER WITH 0.375-0.500 THREAD EXPOSED WHEN SNUG.  
 110 - QC9- Inspect visual per QSI004- Fusion Welds  
 120 - QC5- Inspect part completeness to step on W/O  
 150 - BATCH: \_\_\_\_\_ COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040  
 THICK, PER DART QSI 005 4.9.  
 160 - QC5- Inspect part completeness to step on W/O  
 170 - Identify as per dwg & Stock Location: \_\_\_\_\_  
 180 - QC21- Final Inspection - Work Order Release

### Job BOM

| Part / Item | Component Name       | Quantity     | Operation                     | Container |
|-------------|----------------------|--------------|-------------------------------|-----------|
| D5617-1     | Clamp                | 4 pcs (4 ea) | 100-Large Fab - Welded Assy-1 |           |
| D5678-1     | Hex Nut              | 4 pcs (4 ea) | 100-Large Fab - Welded Assy-1 |           |
| D5735-3     | MID Wearplate        | 1 pcs (1 ea) | 100-Large Fab - Welded Assy-1 | S233474   |
| D5736-043   | MID Wearbar Assembly | 2 pcs (2 ea) | 100-Large Fab - Welded Assy-1 | S235023   |

### Job Allocations

| Operation                     | Component Part | Required | Inventory | Allocated |
|-------------------------------|----------------|----------|-----------|-----------|
| 100-Large Fab - Welded Assy-1 | D5617-1        | 4        | 16        | 0         |
|                               | D5678-1        | 4        | 37        | 0         |
|                               | D5735-3        | 1        | 0         | 0         |
|                               | D5736-043      | 2        | 0         | 0         |

### Part Specifications

Specifications could not be found.

Plex 11/15/19 9:17 AM Dart.lajeunesse.marie





Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

|                                                                                             |  |                                                                                                                    |  |                                                                                                                           |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  |
|---------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------|--|
| Job: 203330                                                                                 |  | DISPOSITION                                                                                                        |  | DEPARTMENT/PROCESS                                                                                                        |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  |
| Part No. D5735-043                                                                          |  | Rework <input type="checkbox"/><br>Scrap <input checked="" type="checkbox"/><br>Use-as-is <input type="checkbox"/> |  | Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input checked="" type="checkbox"/> |  | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/> |  | Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/> |  | Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  |
| Date: 19.11.29                                                                              |  | Sequence #: 100                                                                                                    |  | QTY Affected: 1                                                                                                           |  |                                                                                                                 |  | MRB (QSI042)                                                                                                                         |  |                                                                                                                                                     |  |
| Description Work Order Deviation                                                            |  |                                                                                                                    |  | Disposition                                                                                                               |  |                                                                                                                 |  | DAS 9 9-89 19.11.29                                                                                                                  |  |                                                                                                                                                     |  |
| Wearbar were not welded in the same orientation, causing the welds on the bar to be offset. |  |                                                                                                                    |  | aesthetically not acceptable scrap destroy.                                                                               |  |                                                                                                                 |  | Completed By EL 19.11.29                                                                                                             |  |                                                                                                                                                     |  |
|                                                                                             |  |                                                                                                                    |  |                                                                                                                           |  |                                                                                                                 |  | Lead hand / Supervisor EL 19.11.29                                                                                                   |  |                                                                                                                                                     |  |
|                                                                                             |  |                                                                                                                    |  |                                                                                                                           |  |                                                                                                                 |  | QC / QA Coordinator DAS 9 9-89 19.11.29                                                                                              |  |                                                                                                                                                     |  |
| Root Cause                                                                                  |  | FAULT CATEGORY                                                                                                     |  |                                                                                                                           |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  |
| Operator <input checked="" type="checkbox"/>                                                |  | <input type="checkbox"/> Pressure/Forced                                                                           |  | <input type="checkbox"/> Contamination                                                                                    |  | <input type="checkbox"/> Power Loss/Surge                                                                       |  | <input checked="" type="checkbox"/> Positioned Wrong                                                                                 |  |                                                                                                                                                     |  |
| Manufacturing Process <input type="checkbox"/>                                              |  | <input type="checkbox"/> Bending                                                                                   |  | <input type="checkbox"/> Misaligned/off center                                                                            |  | <input type="checkbox"/> Folio/Program                                                                          |  | <input type="checkbox"/> Outside Tolerance                                                                                           |  |                                                                                                                                                     |  |
| Equip/Tooling <input type="checkbox"/>                                                      |  | <input type="checkbox"/> Crushing                                                                                  |  | <input type="checkbox"/> BOM/Route                                                                                        |  | <input type="checkbox"/> Grain Direction                                                                        |  | <input type="checkbox"/> Drawing                                                                                                     |  |                                                                                                                                                     |  |
| Handling/Presservation <input type="checkbox"/>                                             |  | <input type="checkbox"/> Cracks                                                                                    |  | <input type="checkbox"/> Broken/Damage/Defect                                                                             |  | <input type="checkbox"/> Weld                                                                                   |  | <input type="checkbox"/> Finish                                                                                                      |  |                                                                                                                                                     |  |
| Material <input type="checkbox"/>                                                           |  | <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist                                                              |  | <input type="checkbox"/> Incomplete/Unclear Instructions                                                                  |  | <input type="checkbox"/> Wrong Stock Pulled                                                                     |  | <input type="checkbox"/> Part Lost/Missing                                                                                           |  |                                                                                                                                                     |  |
| Product Improvement <input type="checkbox"/>                                                |  | <input type="checkbox"/> Marks/Chatter                                                                             |  | <input type="checkbox"/> Drill Holes                                                                                      |  | <input type="checkbox"/> Out of Sequence                                                                        |  | <input type="checkbox"/> Misread                                                                                                     |  |                                                                                                                                                     |  |
| Process Improvement <input type="checkbox"/>                                                |  | <input type="checkbox"/> Mislabeled                                                                                |  | <input type="checkbox"/> Fit/Function                                                                                     |  | <input type="checkbox"/> Off-set/Set-up                                                                         |  |                                                                                                                                      |  |                                                                                                                                                     |  |
| Human Factors <input type="checkbox"/>                                                      |  | Other/Details:                                                                                                     |  |                                                                                                                           |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  |